



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3883-1

Job Sheet 168601



Part No: D3883-1

Job Qty: 6 ea **14 MO**

Part Name: Saddle, Outboard LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/20/17

Job Tracking No:

Due Date: ~~11/27/17~~ **12 DEC.**

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D IPP RevA: New issue DD verified by: EC IPP REV: B 15.05.20 remove inside powdercoat DD
VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	11/24/17	11/24/17	0.00	0.00	Start Up Machining		FK 17-12-18
100	CNC Vertical Machining	6 pcs	11/24/17	11/24/17	0.86	12.50	HAAS 1		FK 17-12-18
105	Mill Conv	6 pcs	11/25/17	11/25/17	0.00	12.39	Mill Conv 1		FK 17-12-18
110	QC	6 pcs	11/25/17	11/25/17	0.00	0.00	QC2		FK 17-12-18
120	QC	6 pcs	11/25/17	11/25/17	0.00	0.00	QC8		FK 17-12-19
130	HandFinish	6 pcs	11/25/17	11/25/17	0.00	0.44	HandFinish1		BED 17-12-19
140	Powdercoat	6 pcs	11/27/17	11/27/17	0.00	0.20	Powdercoat1		BR 17-12-20
150	QC	6 pcs	11/27/17	11/27/17	0.00	0.00	QC3		AT 17-12-20
160	Packaging	6 pcs	11/27/17	11/27/17	0.00	0.00	Packaging3		AT 17-12-20
170	QC21-SA	6 Ea	11/27/17	11/27/17	0.00	0.00	QC21		AT 17-12-20

Part Op 100 - Program Batch No. _____ 1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets
Descriptions: 3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets MILL AS PER DWG AND FOLIO FA815
105 - MILL KEYWAY AS PER DWG
140 - ***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED
ON DWG (SEE NOTE 2)*** **DO NOT MASK INSIDE FLANGE SURFACE***

IN 138467. START: 5:20 CUT: 3:20 FINISH: 5:50

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-015	6	11	0	0

Part Specifications

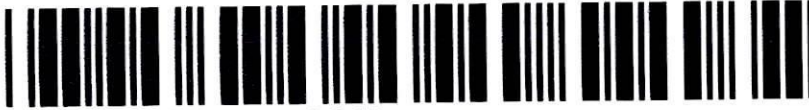
Specifications could not be found.

Plex 11/20/17 8:23 AM dart.lacelle.linda

DART
AEROSPACE
S022646

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Saddle, Outboard LH

PART NO: D3883 – 1

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/15/17

Job No: 168601

DART AEROSPACE LTD		Work Order: 168601
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.644	.645	.645	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.616	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.154	.152	.151	.151		
K	0.240	0.260		.251	.248	.248	.247		
L	0.115	0.135		.125	.122	.125	.125		
M	0.140	0.165		.153	.150	.150	.150		
N	0.720	0.780		.780	.780	.780	.780		
O	0.240	0.260		.256	.257	.254	.255		
P	0.110	0.140		.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.857	2.857	2.857	2.857		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		1.000	.999	.998	.998		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.001	6.000	6.001		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.500	.502	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.218	.219	.218	.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by: PK
Date: 17-12-16

Audited by: [Signature]
Date: 17/12/19

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 168601
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.645	.645	.646		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.152	.152	.151	.152		
K	0.240	0.260		.248	.248	.247	.250		
L	0.115	0.135		.125	.124	.125	.124		
M	0.140	0.165		.150	.149	.150	.151		
N	0.720	0.780		.780	.780	.780	.780		
O	0.240	0.260		.254	.255	.254	.256		
P	0.110	0.140		.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.857	2.857	2.856	2.856		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		.998	.999	.999	.998		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.001	6.000	6.001	6.001		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.500	.500	.500	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.219	.219	.219	.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by: 44
Date: 17-12-13

Audited by: [Signature]
Date: 17-12-19

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	168608
Description: Saddle, Outboard, LH		Part Number:	D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	2.870	2.880		2.875	2.875	2.875	2.875		
B	1.433	1.443		1.438	1.438	1.438	1.438		
C	0.638	0.658		.645	.645	.645	.645		
D	3.895	3.905		3.900	3.900	3.900	3.900		
E	0.257	0.262		.257	.257	.257	.257		
F	0.605	0.625		.615	.615	.615	.615		
G	1.120	1.130		1.125	1.125	1.125	1.125		
H	2.245	2.255		2.250	2.250	2.250	2.250		
I	2.000	2.020		2.000	2.000	2.000	2.000		
J	0.140	0.165		.151	.151	.152	.152		
K	0.240	0.260		.248	.248	.249	.250		
L	0.115	0.135		.125	.124	.124	.124		
M	0.140	0.165		.150	.149	.150	.151		
N	0.720	0.780		.780	.780	.780	.780		
O	0.240	0.260		.255	.255	.254	.255		
P	0.110	0.140		.135	.135	.135	.135		
Q	0.178	0.198		.188	.188	.188	.188		
R	2.825	2.885		2.856	2.856	2.857	2.857		
S	0.316	0.321		.316	.316	.316	.316		
T	0.990	1.010		.999	.999	.998	.999		
U	1.745	1.755		1.750	1.750	1.750	1.750		
V	5.990	6.010		6.000	6.000	6.000	6.000		
W	1.245	1.255		1.250	1.250	1.250	1.250		
X	0.490	0.510		.501	.500	.499	.500		
Y	1.220	1.280		1.250	1.250	1.250	1.250		
Z	2.495	2.505		2.500	2.500	2.500	2.500		
AA	0.313	0.318		.313	.313	.313	.313		
AB	0.020	0.040		.030	.030	.030	.030		
AC	0.760	0.765		.760	.760	.760	.760		
AD	0.215	0.220		.219	.219	.219	.219		
AE	1.265	1.285		1.265	1.265	1.265	1.265		
AF									
Accept/Reject				✓	✓	✓	✓		

Measured by:	F.K.
Date:	17-12-17

Audited by:	✓
Date:	17-12-19

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	

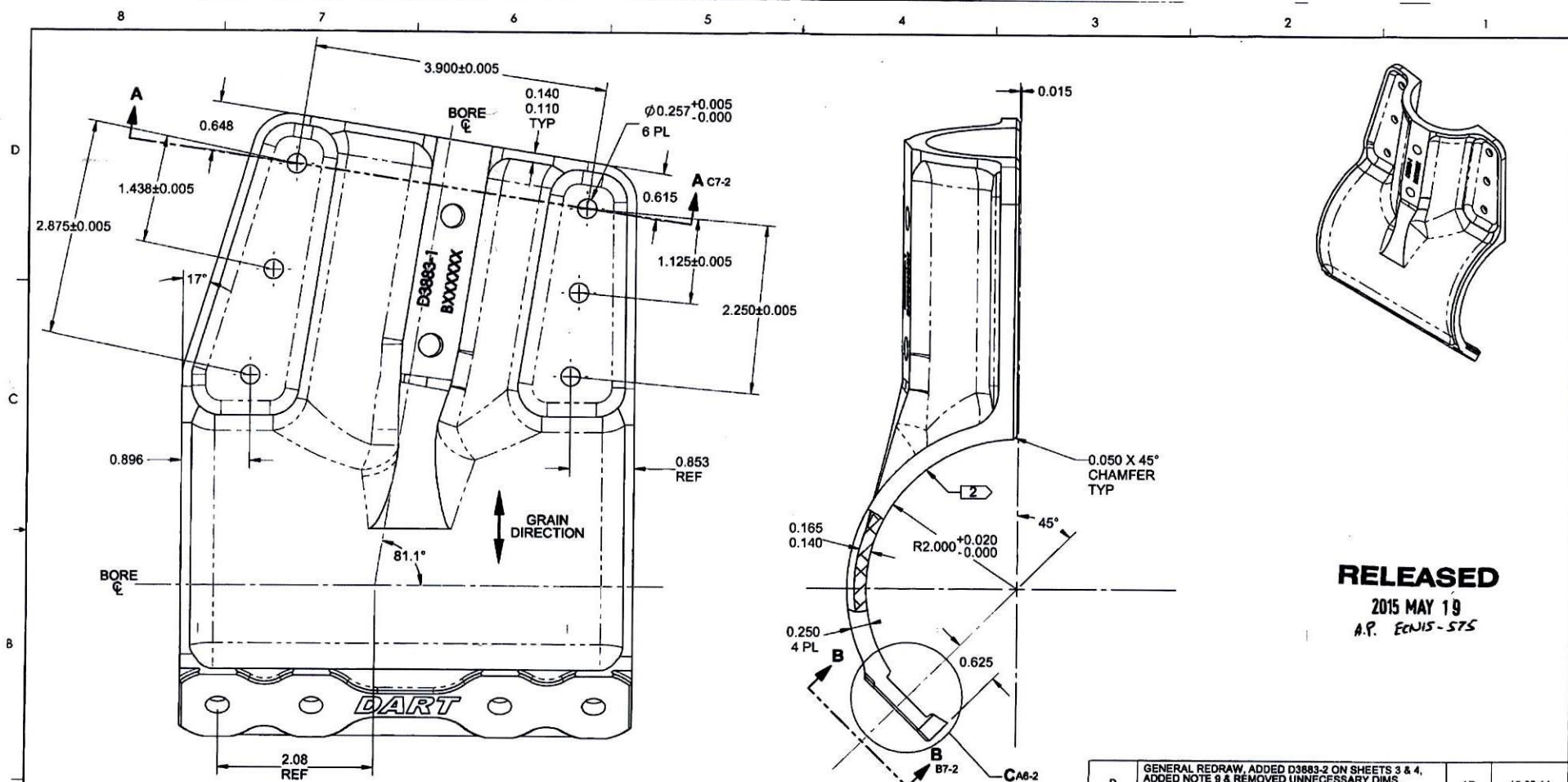
DART AEROSPACE LTD		Work Order:	168601
Description: Saddle, Outboard, LH		Part Number:	D3883-1
Inspection Dwg: D3883	Rev. D	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				13	14	3	4		
A	2.870	2.880		2.875	2.875				
B	1.433	1.443		1.438	1.438				
C	0.638	0.658		.646	.646				
D	3.895	3.905		3.900	3.900				
E	0.257	0.262		.257	.257				
F	0.605	0.625		.615	.615				
G	1.120	1.130		1.125	1.125				
H	2.245	2.255		2.250	2.250				
I	2.000	2.020		2.000	2.000				
J	0.140	0.165		.151	.152				
K	0.240	0.260		.248	.248				
L	0.115	0.135		.125	.124				
M	0.140	0.165		.150	.151				
N	0.720	0.780		.780	.780				
O	0.240	0.260		.255	.256				
P	0.110	0.140		.135	.135				
Q	0.178	0.198		.188	.188				
R	2.825	2.885		2.857	2.857				
S	0.316	0.321		.316	.316				
T	0.990	1.010		.998	.998				
U	1.745	1.755		1.750	1.750				
V	5.990	6.010		6.000	6.001				
W	1.245	1.255		1.250	1.250				
X	0.490	0.510		.501	.500				
Y	1.220	1.280		1.250	1.250				
Z	2.495	2.505		2.500	2.500				
AA	0.313	0.318		.313	.313				
AB	0.020	0.040		.030	.030				
AC	0.760	0.765		.760	.760				
AD	0.215	0.220		.219	.219				
AE	1.265	1.285		1.265	1.265				
AF									
Accept/Reject				/	/				

Measured by: FX	Audited by:
Date: 17-12-18	Date:

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	
C	15.06.22	Dwg Rev updated	KJ	



D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REV.D.SLDPR" WITHOUT NOTICE

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 163601 SB

RELEASED

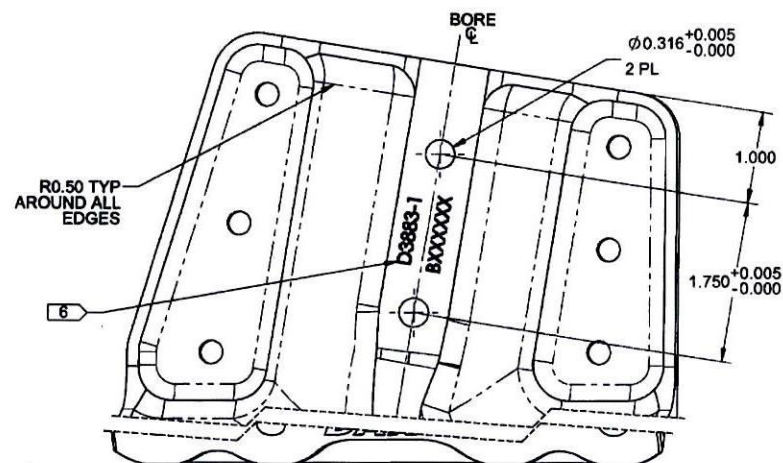
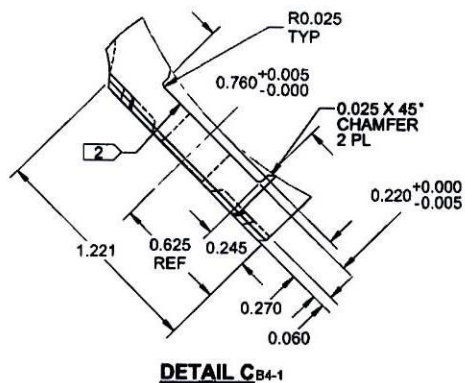
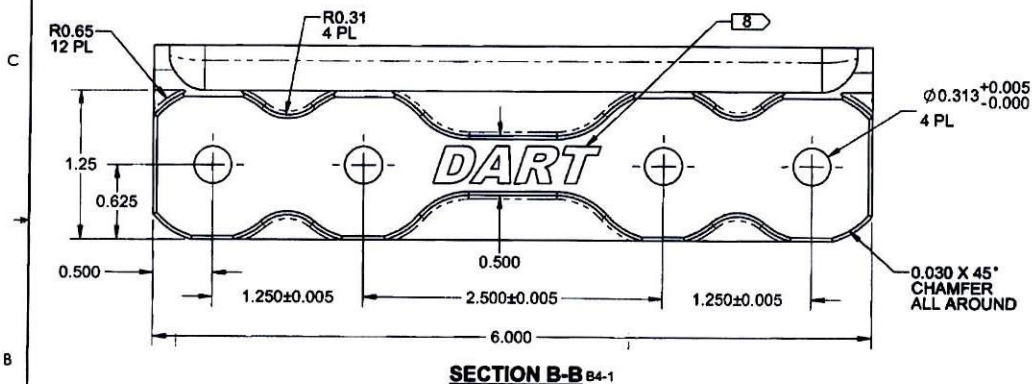
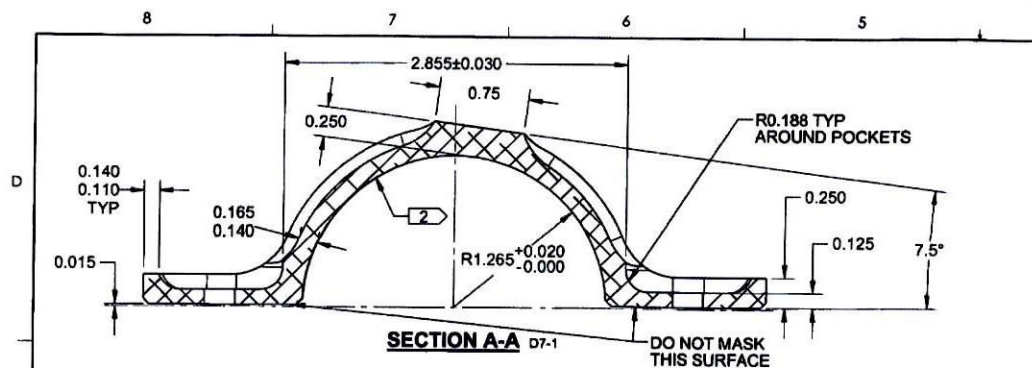
2015 MAY 19

A.P. EENIS-575

D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4, ADDED NOTE 9 & REMOVED UNNECESSARY DIMS, REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1-2	AP	15.02.11
C	ADD R1.285 (ZN D8-2)	RF	09.11.09
B	D6101-015, ZN A7-1; ADD 0.848, ZN D7-1; ADD 0.615, ZN D8-1; ADD 0.125, ZN D7-2; ADD 0.060 & R0.031, ZN B5-2; 0.75 WAS 0.728, ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

NOV 22 2017



RELEASED
A.P. 2015 MAY 19

APPROVED	DESIGN	AP	DART AEROSPACE USA, INC.	
	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
	DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	